

3109



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM631V3027101-1

Job Sheet 176430



Part No: RBEM631V3027101-1

Job Qty: 6 ea

Part Name: Threaded Half



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 4/24/18

Job Tracking No:

Due Date: 4/30/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM631V3027101 REV 1 IPP REV A 18.03.05 NEW ISSUE FK VERIFY DP

Ship Via:

PEC:
NEW
ROUTING

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run hrs Hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	6 Ea		4/30/18	0.00 0.00	Start Up Machining-3		
120	Mori Seiki	6 pcs		4/30/18	0.00 3.00	MORI SL2500Y		
130	QC	6 pcs		4/30/18	0.00 0.00	QC2 Machining-4		
132	Mori Seiki	6 pcs		4/30/18	0.00 0.00	MORI NV5000-2		
134	QC	6 pcs		4/30/18	0.00 0.00	QC2 Machining-2		
140	QC	6 pcs		4/30/18	0.00 0.00	QC8 Machining-4		
170	Outsource	6 pcs		4/30/18		GRO002-VC	10	
180	Packaging	6 pcs		4/30/18	0.00 0.00	Packaging2		
190	QC	6 pcs		4/30/18	0.00 0.00	QC6		
192	Powdercoat	6 pcs		4/30/18	0.00 0.60	Powdercoat13		
194	QC	6 pcs		4/30/18	0.00 0.00	QC3		
200	Packaging	6 pcs		4/30/18	0.00 0.00	Packaging3-1		
210	QC21-SA	6 Ea		4/30/18	0.00 0.00	QC21		

Part Op 120 - 1-Machine as per folio FB997 FOLIO REV: _____ DWG REV: _____ 2-Deburr
 Descriptions: 132 - 1-Machine as per folio FB997 FOLIO REV: _____ DWG REV: _____ 2-USE FIXTURE DT10394
 SAME FIXTURE FOR-1 AND-3 3-Deburr
 170 - -Issue P/O to ALTECH
 192 - 1- Powder coat YELLOW, FED #13538 2- No powder coat on affected area as per DWG START TIME 10:55
 OVEN TEMPERATURE: 180° FINISH TIME: 11:05
 194-Ink Stamp

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R2.000	6061T6 Round Bar 2.00	1.4460 ft (.241 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R2.000	1	22	0

Part Specifications

Specifications could not be found.



Container No: S067018



Part: RBEM631V3027101-1

Job No: 176430

Serial No/Batch: S067018

Revision: 1

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ex 4/24/18 7:49 AM dart.logan.david

DNL 4-24

MAY 05/11

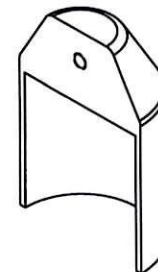
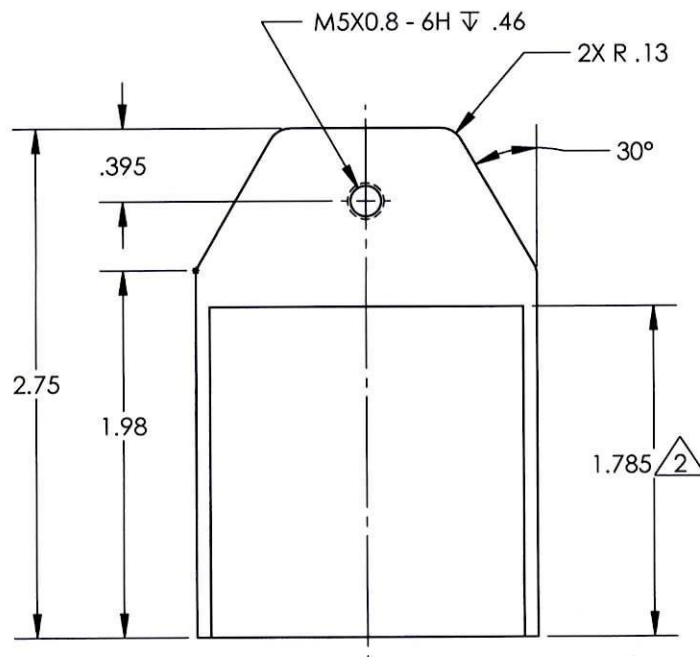
MAY 11 2018
9:38DAS
03
BAG

ALTECH

M 138677

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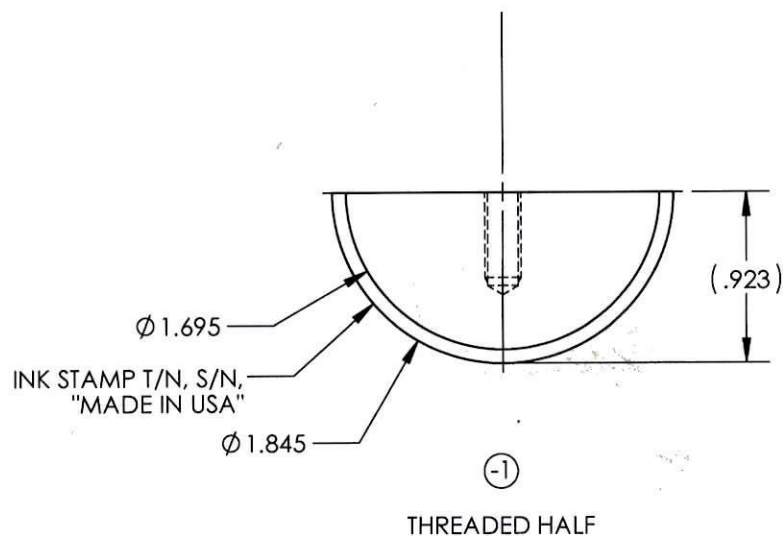
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NO AMENDMENT
NOTICE
WORK ORDER
NO. 176430 7L
20180424

NOTES:

- DUAL FINISH:
1ST: CLEAR ANODIZE
MIL-A-8625 TYPE II CLASS I.
2ND: POWDER COAT YELLOW, FED #13538.
- NO POWDER COAT ON THIS SURFACE.



DART AEROSPACE	
TITLE TORLON BUSH EXCHANGE	
DWG NO. RBEM631V3027101-1	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE NOTE 1	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE NOTE 1	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 3/23/2016 SHEET 2 OF 5

2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039831**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039831
PO Date: 5/8/18
Due Date: 5/10/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176630	RBT400315-7	Bolt -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	5/10/18	10 pcs	0 pcs	10 pcs	\$6.6666666/pcs	\$66.67
Line Item Note *asap*										
2	173761	RBEM642V4001102-1	Base Plate -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	5/10/18	4 pcs	0 pcs	4 pcs	\$7.50/pcs	\$30.00

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	173764	RBEM642V4001102-5	Post 2 -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	5/10/18	4 pcs	0 pcs	4 pcs	\$7.50/pcs	\$30.00
4	173763	RBEM642V4001102-3	Post -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	5/10/18	4 pcs	0 pcs	4 pcs	\$7.50/pcs	\$30.00
5	176430	RBEM631V3027101-1	Threaded Half -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	5/10/18	6 pcs	0 pcs	6 pcs	\$8.00/pcs	\$48.00
6	176431	RBEM631V3027101-3	Counterbore Half -Issue P/O to Groupe Altech: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	5/10/18	5 pcs	0 pcs	5 pcs	\$8.00/pcs	\$40.00
7	173765	RBEM642V4001102-7	Block -Issue P/O to Group Altech: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	5/10/18	4 pcs	0 pcs	4 pcs	\$8.00/pcs	\$32.00

cl



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009132- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-May-2018		Curtis Anderson		39831				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT400315-7 Rev.	RBT400315-7 01 -BLACK OXIDE ON SST MIL-DTL-13924C BLACK OXIDE FINISH MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	10	10	0	0	0
2	RBEM642V4001102-1 Rev.	RBEM642V4001102-1 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ZINC PLATE ASTM B633 TYPE 1 SC2	ZINC CH	4	4	0	0	0
5	RBEM631V3027101-1 Rev.	RBEM631V3027101-1 01 -ANO-CLEAR [ANODIZE CLEAR] CLEAR ANODIZE PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT.	ANODIZE CH	6	6	0	0	0
6	RBEM631V3027101-3 Rev.	RBEM631V3027101-3 01 -ANO-CLEAR [ANODIZE CLEAR] CLEAR ANODIZE PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT.	ANODIZE CH	5	5	0	0	0
7	RBEM642V4001102-7 Rev.	RBEM642V4001102-7 01 -ANO-CLEAR [ANODIZE CLEAR] CLEAR ANODIZE PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT.	ANODIZE CH	4	4	0	0	0
8	RBT400313-9 Rev.	RBT400313-9 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8	0	0	0
9	RBT18547-1 Rev.	RBT18547-1 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0
10	269T9310-3 Rev.	269T9310-3 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE ZINC PLATE ASTM B633 TYPE 2 SC2	ZINC CH	5	5	0	0	0

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BUYER:

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